

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010867**Date Inspected:** 11-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW welding of weld joint NSTL4-3L/L-2B located inside PCMK north tower, lift 4, skin C to skin D. Welder was identified as 050289. ZPMC QC was identified as CWI Gong Laing Zhu (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-3212-TC-U4b-1.

SMAW welding of weld joint NSTL4-3L/L-1B located inside PCMK north tower, skin D to skin E in the top 2 meters of lift 4. Welder was identified as 052930. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-3212-TC-U4b-1.

FCAW welding of weld joint NSTL4-3B/L-1B located inside PCMK north tower, lift 4,skin C to skin D. Welder was identified as 050041. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Gao Zhi Chun, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2232-TC-U4b-F.

FCAW welding of weld joint NSTL4-3B/L-2B located inside PCMK north tower, lift 4,skin D to skin E, between 118 and 119M elevations. Welder was identified as 050041. ZPMC QC was identified as QC1. Assisting QC1 at

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this location and appearing to be monitoring the welding and recording data was ZPMC Gao Zhi Chun, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2232-TC-U4b-F.

FCAW repair welding of weld joint SSTL4-3B/L-3B located inside PCMK south tower, lift 4, approximate 1M repair at 143M elevation. Welder was identified as 053869. ZPMC QC was identified as CWI Tu Jun (QC2). The welding variables recorded by QC2 appeared to comply with WPS-345-FCAW-2G(2F)-repair as listed in ZPMC repair order T-WR2718.

FCAW repair welding of weld joint SSTL4-1B/L-3A located outside PCMK south tower, lift 4, skin A to skin E, approximate 930mm repair at 114M to 115M elevations. Welder was identified as 040343. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Wang Hao, who was not a CWI. The welding variables recorded by QC2 appeared to comply with WPS-345-FCAW-2G(2F)-repair as listed in ZPMC repair order T-WR2718.

SMAW repair welding of weld joint SSTL4-1B/L-5A located outside PCMK south tower, lift 4, skin B to skin C, approximate 200mm repair at 118M elevation. Welder was identified as 056200. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Wang Hao, who was not a CWI. The welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-4G(4F)-repair as listed in ZPMC an unnumbered ZPMC repair order.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW tack welding of weld joint WSD1-FASA3-2C/E-11, 12 located on PCMK west tower, lift 3, skin A, at approximately 91M elevation. Welders were identified as 053310, 206195. ZPMC QC was identified as CWI You Qi Guo (QC3). Assisting QC3 at this location and appearing to be monitoring the welding and recording data was ZPMC Shao Hai Lang, who was not a CWI. The welding variables recorded by QC3's assistant appeared to comply with WPS-B-T-2312-TC-P4-F and WPS-B-T-2313-TC-P4-F. This QA Inspector observed the root opening to be less than 3mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

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Reviewed By: Dawson,Paul

QA Reviewer